

IN THE SPECIFICATION:

Please replace paragraph 22 of the published application, page 5, line 9, to page 7, line 4, of the originally filed specification with the following amended paragraph:

--[0022] Figs. 3 to 9 illustrate consecutive steps of a preferred embodiment of a multi-stage forging method of this invention for disproportionally enlarging an end section of an aluminum alloy tube 3 of a bicycle frame part (see Fig. 9). The method includes the steps of: (a) preparing the aluminum alloy tube 3 having a predetermined length, first and second dies 4, 6 with end sections that respectively define first and second shape-forming cavities 41, 61, and first and second mandrels 5, 7 with shape-forming ends 51, 71 that have cross-sections respectively corresponding to those of the end sections of the first and second dies 4, 6 (see Figs. 6 and 8); (b) drawing the aluminum alloy tube 3 to form a thin section 31 and a thick end section 32 extending from the thin section 31, wherein the thin section 3 has a wall thickness thinner than that of the thick end section 32 (see Fig. 4); (c) inserting the thin section 31 of the aluminum alloy tube 3 into the first shape-forming cavity 41 in the first die 4, as illustrated in Fig. 5; (d) radially and proportionally enlarging the cross-section of the thick end section 32 of the aluminum alloy tube 3 relative to a centerline (X) of the aluminum alloy tube 3 by forging the aluminum alloy tube 3 in the first shape-forming cavity 41 with the shape-forming end 51 of the first mandrel 5 ~~50~~ 5 inserted into the thick end section 32 of the aluminum alloy tube 3 in such a manner that the wall thickness of the thick end section 32 after being enlarged is substantially the same as that of the thin section 31, as best illustrated in Fig. 6; and (e) disproportionally varying the cross-section of the thick end

section 32 of the aluminum alloy tube 3 by forging the aluminum alloy tube 3 obtained in step (d) in the second shape-forming cavity 61 with the shape-forming end 71 of the second mandrel ~~70~~ 7 inserted into the thick end section 32 of the aluminum alloy tube 3, as illustrated in Figs. 7 to 9. The thick end section 32 of the aluminum alloy tube 3 is forged in step (e) in such a manner that a portion 321 of the cross-section of the thick end section 32 of the aluminum alloy tube 3 is reduced and the remaining portion 322 of the cross-section of the thick end section 32 of the aluminum alloy tube 3 is further enlarged (see Fig. 7) , and that the perimeter of an end edge 324 of the end section 32 of the aluminum alloy tube 3 obtained after step (e) (see Fig. 9) is substantially equal to that of the end edge 324 of the thick end section 32 of the aluminum alloy tube 3 obtained after step (d) and before step (e).